

Work Order ID 84186

84186

Page 1

Item ID: D412-698-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cabin Door Roller, LH

Start Date: 07/05/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 23/05/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-698-011 CHG003

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

MLJ 12/05/22

2

2

12/05/22 JB

Sr/aly

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84186

84186

May-07-12 11:05:06 AM

Item ID: D412-698-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Cabin Door Roller, LH

Stop ***NS2***

Start Date: 07/05/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 23/05/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-011								
	Location: <u>62</u> <u>Rec B</u>								
140									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

2 12/6/11

MLJ 12/06/11

mf
12-06-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-07-12 11:05:09 AM

Page 1

Work Order ID: 84186

84186

Parent Item: D412-698-011

D412-698-011

Parent Item Name: Cabin Door Roller, LH

Start Date: 07/05/2012

Required Date: 23/05/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C04.02.26Change Qty of D3121-141 & remove D3121-145 from
Step 1,3KJ/DS
IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-141		Manufactured	No			100	Each	0.0000	3	6	✓		
Sz *D3121-141*									**	83457	JB	5	
Bracket Assembly													
D3121-143		Manufactured	No			110	Each	6.0000	1	2	✓		
Sz *D3121-143*									**		JB		
Bracket Assembly													
<div>Location</div> <div>Loc Qty</div> <div>Loc Code</div>													
				ST235A				6					
				75031				2		75031	✓		
				80098				4					
D3183-043		Manufactured	No			110	Each	1.0000	0	2	✓		
Sz *D3183-043*									**	1x 82688	JB		
Bracket Assembly													
<div>Location</div> <div>Loc Qty</div> <div>Loc Code</div>													
				ST235				1					
				75033				1		1x 75033	5		
D3137-043		Manufactured	No			110	Each	4.0000	2	2	✓		
Sz *D3137-043*									**	83467	JB	12/05/22	
Bracket Assembly													
<div>Location</div> <div>Loc Qty</div> <div>Loc Code</div>													
				ST235B				4					
				79734				4					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

May-07-12 11:05:09 AM

Page 2

Work Order ID: 84186

84186

Parent Item: D412-698-011

D412-698-011

Parent Item Name: Cabin Door Roller, LH

Start Date: 07/05/2012

Required Date: 23/05/2012

Start Qty: 2.00

Required Qty: 2.00

D3199-1

Manufactured No

110

Each

31.0000

9

18

**

D3199-1

Bracket

Location

Loc Qty

Loc Code

ST236

36

78618

2

82687

29

ST236A

-5

Manufactured No

110

Each

15.0000

1

2

**

D3202-1

D3202-1

Cover

Location

Loc Qty

Loc Code

ST241A

15

70294

2

82663

13

JB
B83860 SP.

11x 82687 5
1 2

JB 12/05/22

82663

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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Revision: E

Date: 08.05.01